

Date: Wednesday, 7/11/2007 3:05:16 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER ASSEMBLY
Job Number	: 33504		
Estimate Number	: 10295		
P.O. Number	: <u>N/A</u>	Part Number	: D3220042
This Issue	: 7/11/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3220 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL / MED FAB	Drawing Revision	: A1
Previous Run	: 33494C	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 7/27/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev. A New Issue 05-11-06 JLM Est: B 06.11.15 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.7266 sf(s)/Unit Total : 14.5320 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick
 (M2024T3S.050
 Identify for D3220-2
 Batch: M103 321

SAD 07/07/29

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut D3220-1 as per Dwg D3220
 Dwg Rev: A1
 Prog Rev: A1

2-Deburr if necessary

SAD 07/07/30 (20)

SAD 07/07/29

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/07/29

(20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/07/30

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 07/07/31

X20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 33504

Part Number: D3220042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-C'sink D3220-2 as per Dwg D3220

ml 07/07/31 x20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/01 (x20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL 07-08-01 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/08/02 x20

9.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number

Description Batch

8 MS20426AD3-4

Rivet

M102404

6

10.0

MS21059L4

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21059L4

Nutplate

M102909

6 7/8/01 (20)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3220-042 doubler as per Dwg D3220

ml 07/08/02 x20

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/03 (x20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/08/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 3:05:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 33504

Part Number: D3220042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

[Signature] 07/08/03 (20)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

[Signature] 07/08/03

Job Completion



[Signature] 07-08-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

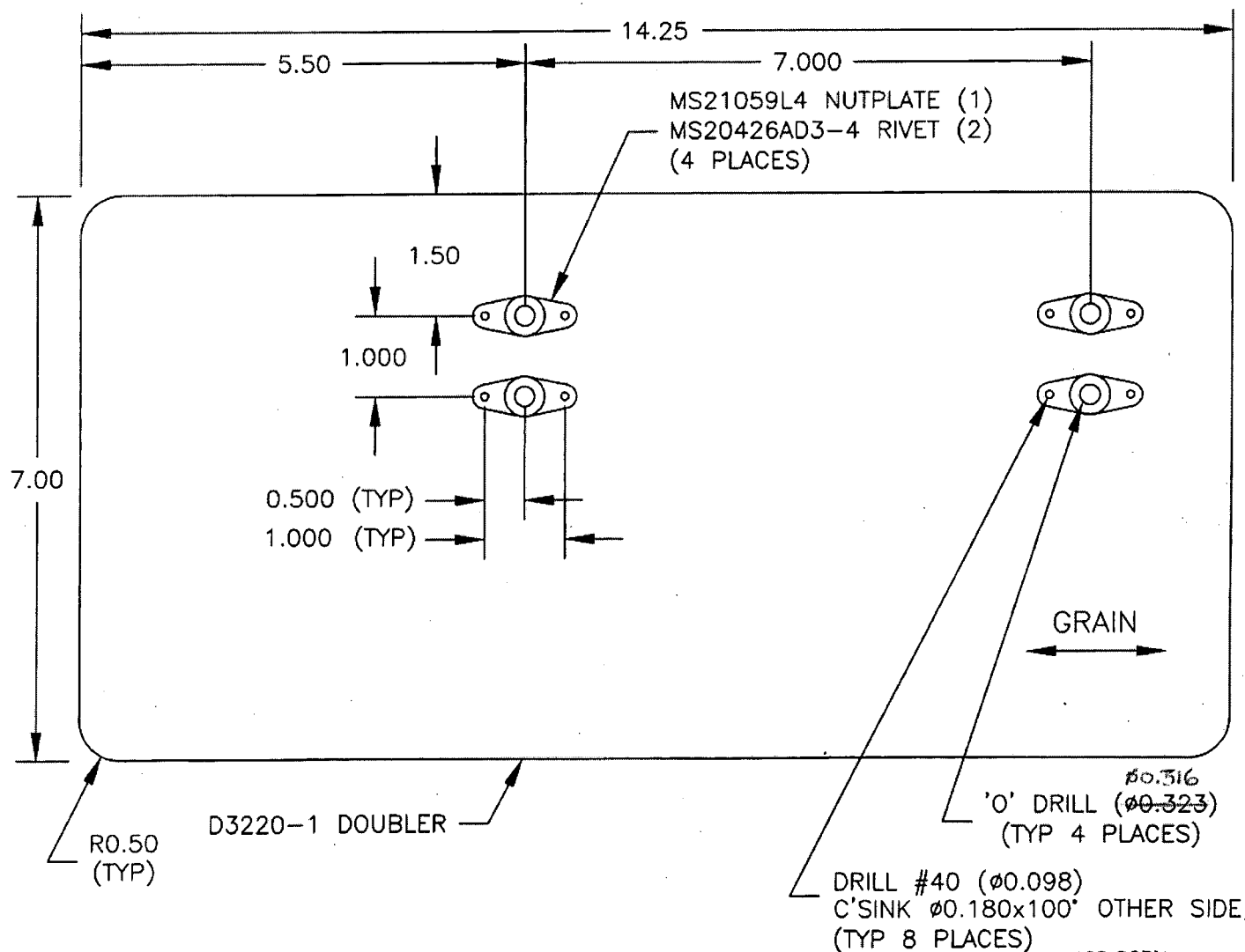
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>#</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3220	SHEET 1 OF 2
DATE	03.10.16	TITLE	DOUBLER	SCALE	1:2
A	03.10.16	NEW ISSUE			
A1	<i>CP</i> <i>#</i> 03.11.13	CORRECTED DIM.			

RELEASED
03.11.14 *#*



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE

WORK ORDER
NO. *33504*

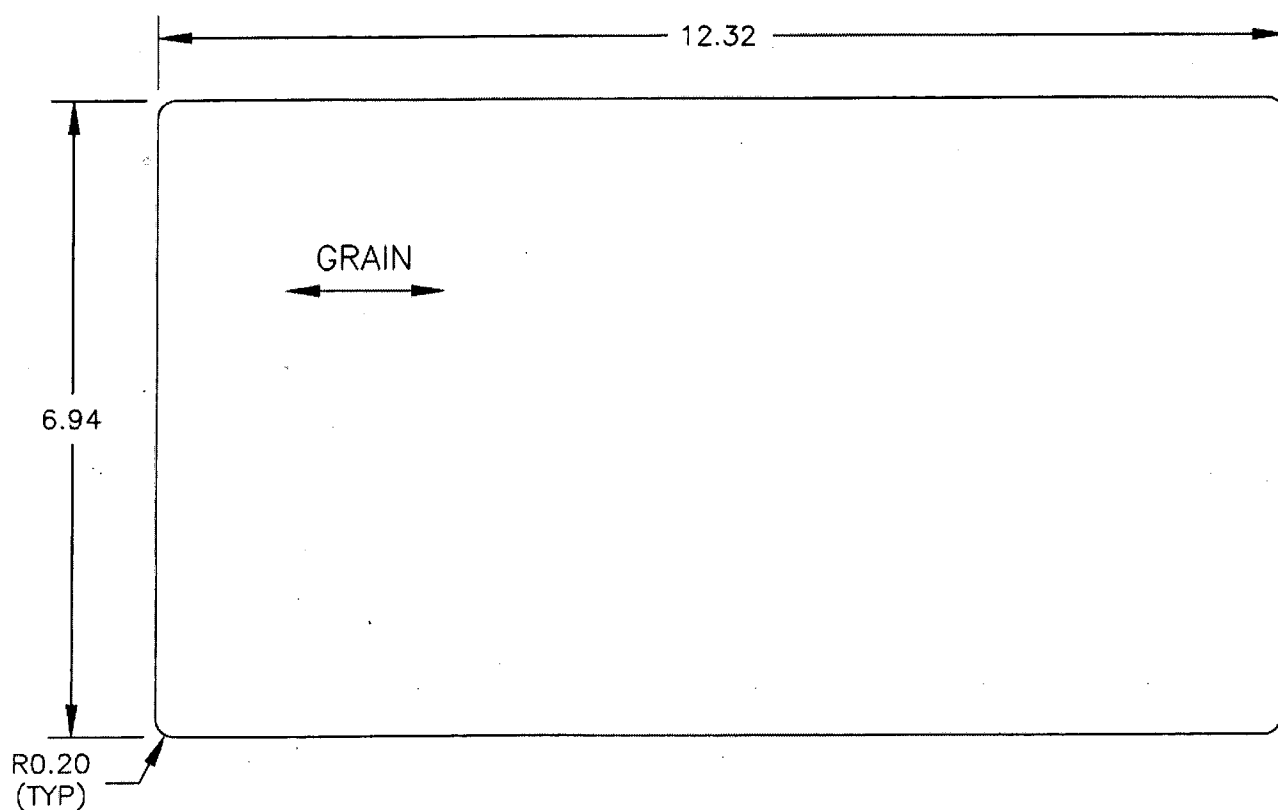
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DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3220	REV. A SHEET 2 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2

RELEASED
03.11.14 #



D3220-3 DOUBLER

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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